



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4275-1
Job Sheet 177985



Part No: D4275-1

Job Qty: 4 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/24/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Machining-2		K.F. 18-06-07
100	Bandsaw	4 pcs	6/8/18	6/8/18	0.00	0.42	Bandsaw1		K.F. 18-06-07
110	CNC Vertical Machining	4 pcs	6/8/18	6/8/18	0.71	7.41	HAAS1-4		K.F. 18-06-07
120	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC2 Machining-2		K.F. 18-06-07
130	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC8 Machining-2		K.F. 18-06-07
140	HandFinish	4 pcs	6/8/18	6/8/18	0.00	0.60	HandFinish1		SA 18-06-12
145	Powdercoat	4 pcs	6/8/18	6/8/18	0.00	0.51	Powdercoat1		BK 18-06-13
150	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC3	DAS	JUN 13 2018
180	Packaging	4 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-2	6	JUN 14 2018
190	QC21-SA	4 Ea	6/8/18	6/8/18	0.00	0.00	QC21	9-89	JUN 14 2018

Part Op 100 - Cut Blank TO 39.750" Batch:

Descriptions: 110 - 1-Machine per folio FB006 2- deburr rough edges

145 - MASK AS PER DWG

M 138839 START: 9:00 OUT: 3:00 FINISH: 9:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	13.2500 ft (3.3125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	13	23	0

Part Specifications

Specifications could not be found.

Plex 5/24/18 9:19 AM Dart.lajeunesse.marie

5059687 4x = 13.25 pi.
5079466

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐											
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval									
Description Work Order Deviation			Disposition										
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S079467 Part: D4275-1 Job No: 177985 Serial No/Batch: S079467 Revision: Inspector: Exp Date: Instructions: Date: 06/09/18			Completed By										
			Lead hand / Supervisor Approval Verification										
			QC / QA Coordinator Approval										
			Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Pre: _____ Ben _____ Cen _____ Cra _____ Crir _____ Cuf _____ Cru _____ Hea _____ </td> <td style="width:33%;"> Wave/Twist in Tube _____ Marks/Chatter _____ </td> <td style="width:33%;"> Instructions Incomplete/Unclear _____ Drill Holes _____ </td> </tr> <tr> <td colspan="3" style="text-align: center;"> Fit/Function _____ Misaligned/off center _____ </td> </tr> </table>			Pre: _____ Ben _____ Cen _____ Cra _____ Crir _____ Cuf _____ Cru _____ Hea _____	Wave/Twist in Tube _____ Marks/Chatter _____	Instructions Incomplete/Unclear _____ Drill Holes _____
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Fit/Function _____ Misaligned/off center _____													
OTHER :			Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence										

DART AEROSPACE LTD		Work Order: 177981
Description: Fwd Beam		Part Number: D4275-1
Inspection Dwg: D4275	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.751	✓		Ver	
26.700	+/-0.010	26.700	✓		TAPE	
Ø0.381	+0.000/-0.001	Ø.380	✓		G.P	
8.280	+/-0.010	8.280	✓		TAPE	
1.44	+/-0.030	1.44	✓		Ver	
0.95	+/-0.030	0.950	✓		Ver	
3.50	+/-0.030	3.50	U		Ver	
13.28	+/-0.030	13.28	✓		Ver	
13.50	+/-0.030	13.50	✓		TAPE	
9.25	+/-0.030	9.25	✓		TAPE	
5.00	+/-0.030	5.00	✓		Ver	
0.75	+/-0.030	0.75	✓		Ver	
2.75	+/-0.030	2.750	✓		Ver	
3.00	+/-0.030	3.005	U		Ver	
1.250	+/-0.010	1.254	✓		Ver	
4.50	+/-0.030	4.50	U		Ver	
0.734	+/-0.010	0.734	U		Ver	
0.108	+/-0.010	0.108	✓		H.G.	
39.48	+/-0.030	39.48	U		TAPE	
0.95	+/-0.030	0.95	✓		Ver	
0.60	+/-0.030	0.605	✓		Ver	
1.750	+/-0.010	1.749	✓		Ver	
2.700	+/-0.010	2.695	✓		Ver	
1.10	+/-0.030	1.102	✓		Ver	
1.25	+/-0.030	1.254	U		Ver	
0.900	+/-0.010	0.899	U		Ver	
0.75	+/-0.030	0.753	U		Ver	
0.250	+/-0.010	0.252	U		Ver	
3.000	+/-0.010	2.996	✓		Ver	
1.500	+/-0.010	1.498	✓		Ver	
Ø0.191	+0.005/-0.001	0.194	✓		G.P	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
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